

Work Order ID 73226

Page 1

Friday, August 26, 2011 10:27:12 AM

Item ID: D3315-2

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 8/26/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: CL

Date: 11/08/20

QC:

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr Revision Nbr

D3315 Rev B

100



FLOW WATER JET

Waterjet

FLOW CNC Waterjet
1010 .063

Memo

1-Cut as per Dwg D. Dwg Rev: R Prog Rev: R 2-Deburr if necessary

B11-8-30

110



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

Memo

0.00

B11-8-30

120



QC8- Inspect parts - second check

QC

Quality Control

Memo

0.00

0.00

8/4/08/80

(72)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop


**Sequence ID/
Work Center ID**
**Operation
Description**
**Set Up/
Run Hours**
Tool ID
Tool #
**Plan
Code**
**Accept
Qty**
**Reject
Qty**
**Reject
Number**
**Insp.
Stamp**

130



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

Deburr if necessary

WIP

140



NC BRAKE

0.00

Brake NC

Memo

0.00

Brake NC

1- Form using DT8751 Die as per Dwg D3315Rev: B 2- Form using DT8179 Die and form joggle using DT8157 as per Dwg D3315Rev: B

SP 11/09/01 *SP 11/09/01*

150



QC6- Inspect dimensions to drawing

0.00

QC

Memo

0.00

Quality Control

Su 10/06

+2
-2

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Item Name: Wearplate

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Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

190



Powdercoat

Powder Coating

W 117338

Memo

START TIME:

320°^F

FINISH TIME: 8:50

Set Up/
Run Hours

200



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

210



Packaging

Packaging

Packaging

0.00

Memo

0.00

Identify on inside surface using a permanent fine point marker with the following:
 TCCA-PDA, Dart Aerospace Ltd. P/N: D3315-2, B/N: BXXXXXX For Product Eligibility see PDA04-17 and Stock Location: ST 496

TX m-f 11/01/14

COUNT &
MEASURED

7 4 41 108116

(TX)

SP 11-09-14

C

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Start Date: 8/26/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/15

MF
11-09-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Friday, August 26, 2011 10:27:10 AM

Work Order ID: 73226



Parent Item: D3315-2



Parent Item Name: Wearplate

Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP: A□05.05.12□New issue□KJ/JLM□

IPP Rev:B As per Rev B 06-03-24 JLM

IPP Rev:C now water jet 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S16GA 1010/1025 sheet 16GA		Purchased		No		100	sf	134.3000	1.695	10.17	12	B11-8-30	

Location Loc Qty Loc Code

MAT019	134.3	
116791	32.5	
117500	101.8	

117500

(7)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	73226
Description: Wearplate	Part Number:	D3315-2
Inspection Dwg: D3315 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.266 x 0.450	+0.006/-0.001 x +/-0.010	266X 453	✓		V HBGZ	
4.402	+/-0.010	4.400	✓		V	
4.137	+/-0.010	4.137	✗		V	
3.550	+/-0.010	3.555	✗		V	
5.464	+/-0.010	5.468	✓		V	
5.214	+/-0.010	5.214	✗		V	
1.224	+/-0.010	1.226	✗		V	
2.57	+/-0.030	2.579	✗		V	
6.273	+/-0.010	6.270	✗		V	
8.224	+/-0.010	8.227	✗		PROJ502	
9.515	+/-0.010	9.519	✗		P	
11.429	+/-0.010	11.426	✗		P	
15.474	+/-0.010	15.474	✗		T B01	
16.379	+/-0.010	16.379	✗		T	
21.360	+/-0.010	21.360	✗		T	
23.474	+/-0.010	23.474	○		T	
26.273	+/-0.010	26.273	○		T	
29.42	+/-0.030	29.42	✗		T	
0.060	+/-0.010	.063	✗		V	
Ø0.300	+0.006/-0.001	.0302	✗		V	

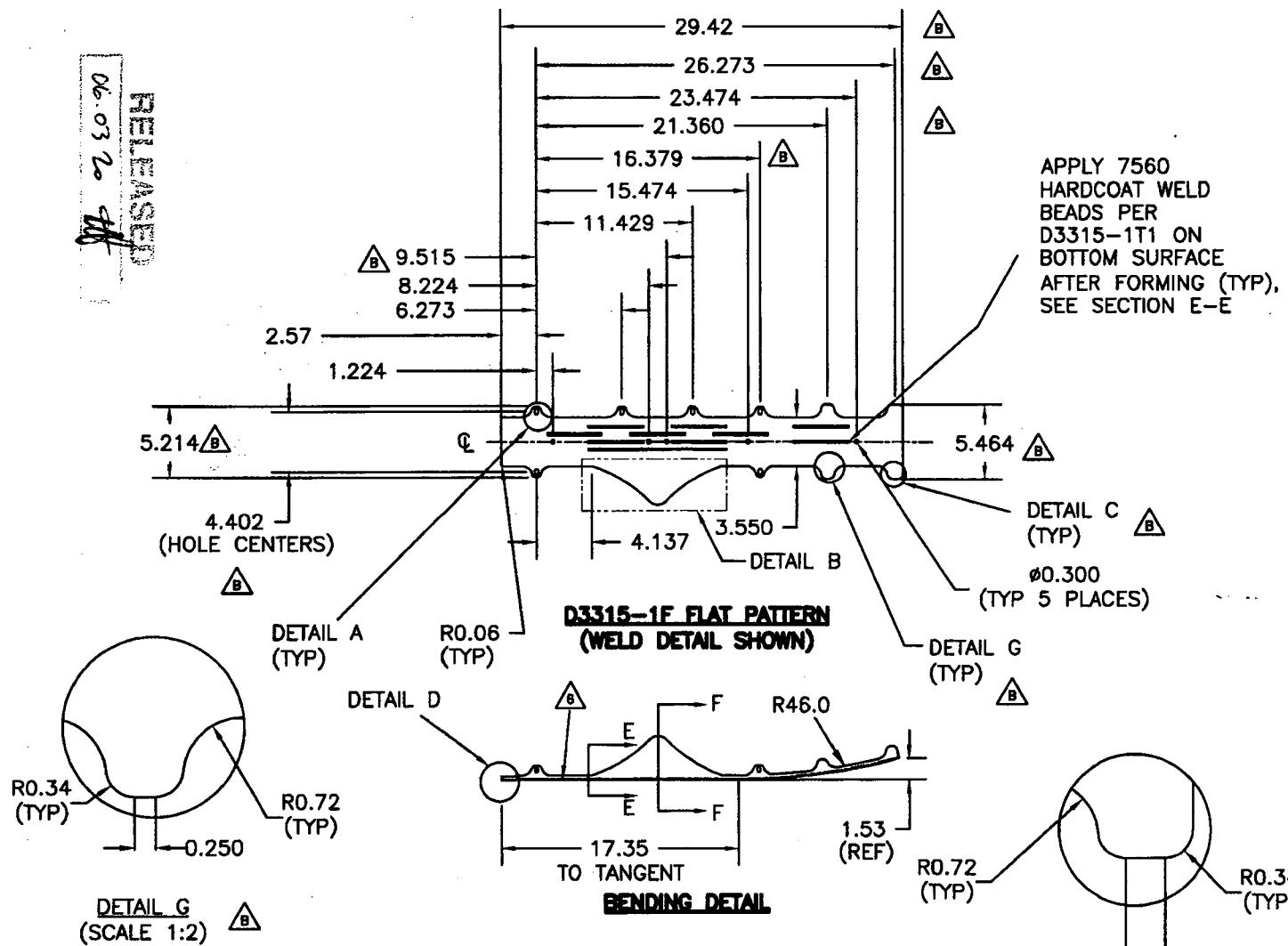
Measured by:	HB	Audited by:	S	Prototype Approval:	N/A
Date:	11-8-30	Date:	11/04/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.09.28	New Issue	KJ	M



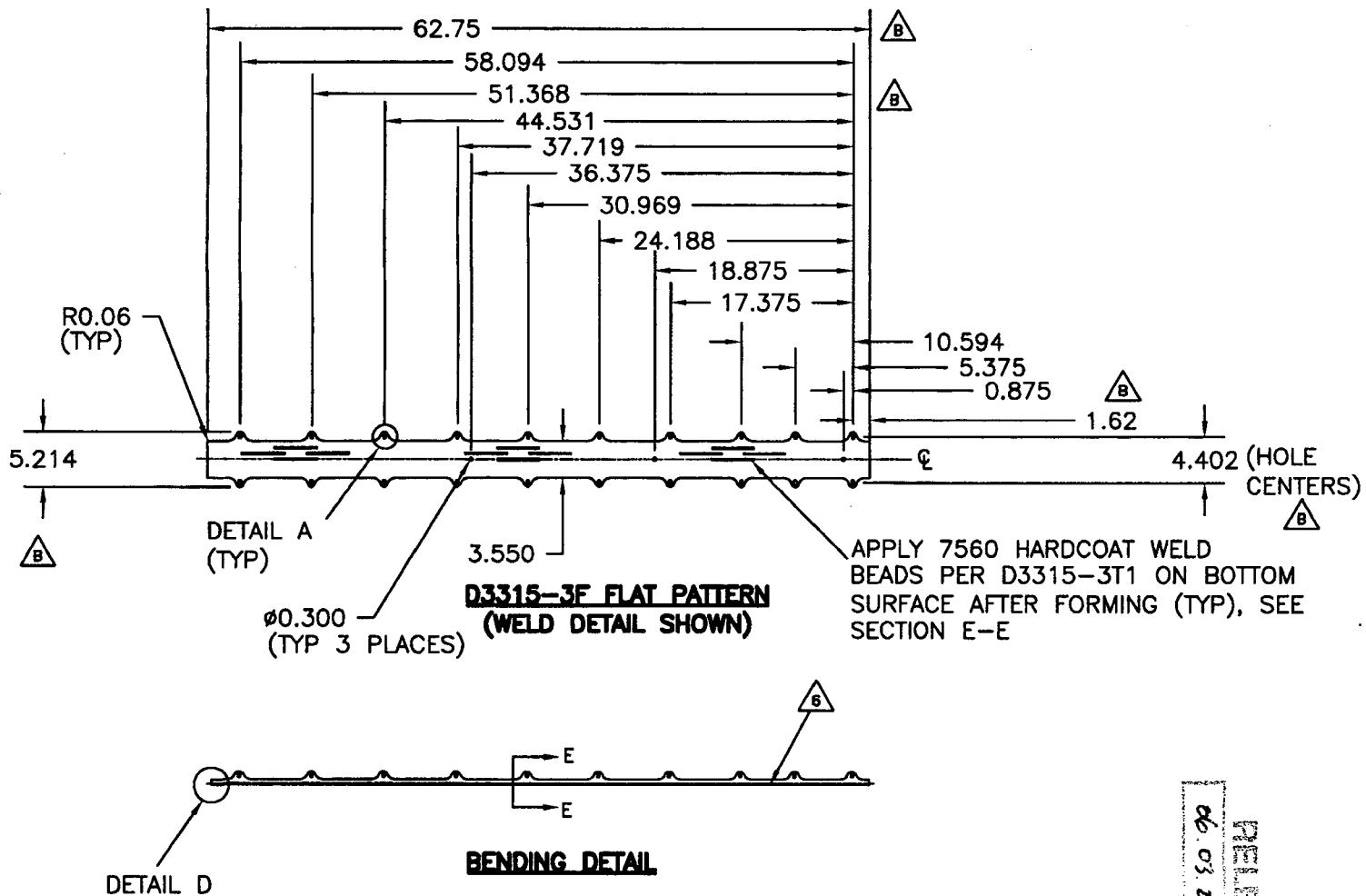
DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>MM</i>	APPROVED <i>MM</i>	DRAWING NO. D3315
DATE 06.01.31	TITLE WEARPLATE	REV. B
A 04.09.10	NEW ISSUE	SHEET 1 OF 4
B 06.01.31	UPDATE DIMENSIONS	SCALE 1:12

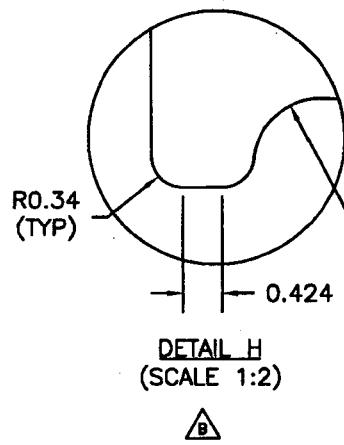


DART

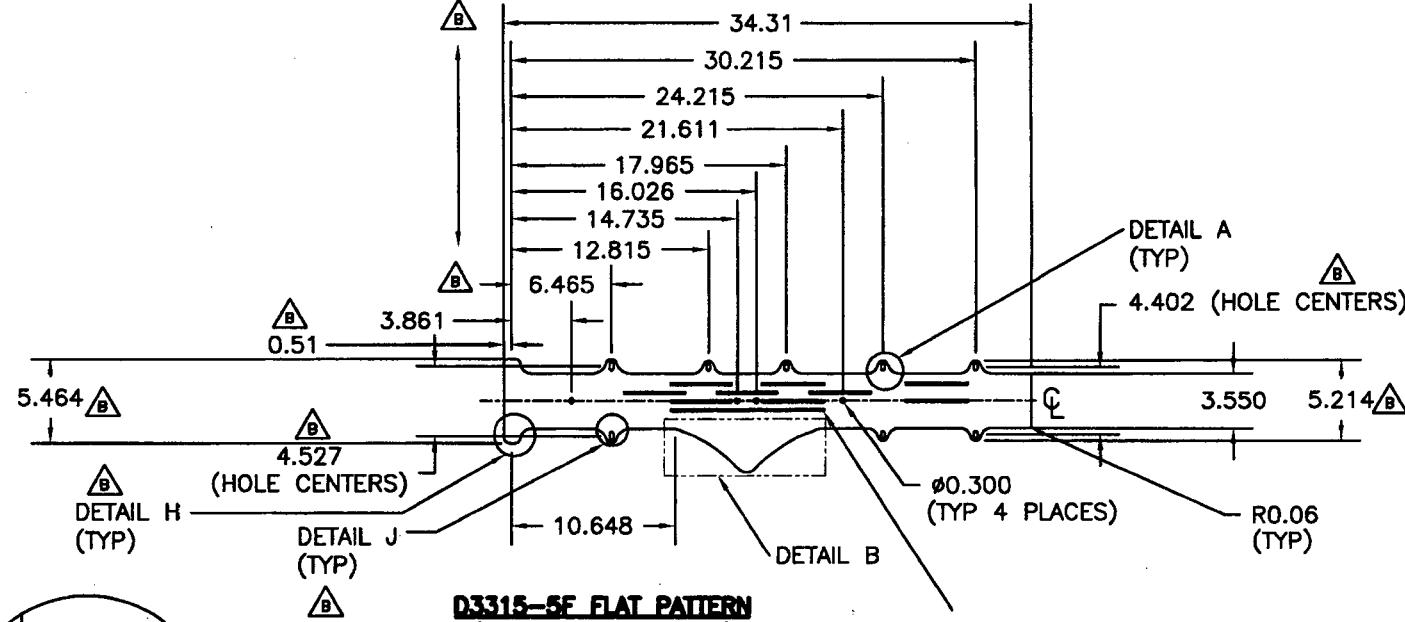
DESIGN <i>P4</i>	DRAWN BY <i>P4</i>	DART AEROSPACE LTD	
CHECKED <i>M</i>	APPROVED <i>M</i>	DRAWING NO.	HAWKESBURY, ONTARIO, CANADA
DATE 06.01.31		TITLE	D3315
		SCALE	REV. B SHEET 2 OF 4 1:16

**D3315-3 WEARPLATE SHOWN (-4 OPPOSITE)**

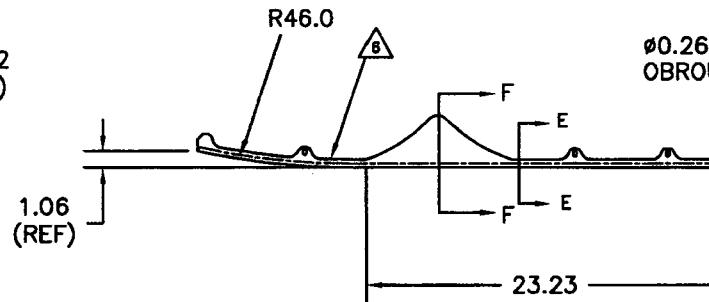
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"



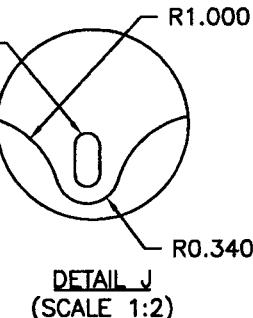
06.01.31
06.01.31



APPLY 7560 HARDCOAT WELD
BEADS PER D3315-5T1 ON BOTTOM SURFACE
AFTER FORMING (TYP), SEE SECTION E-E



BENDING DETAIL



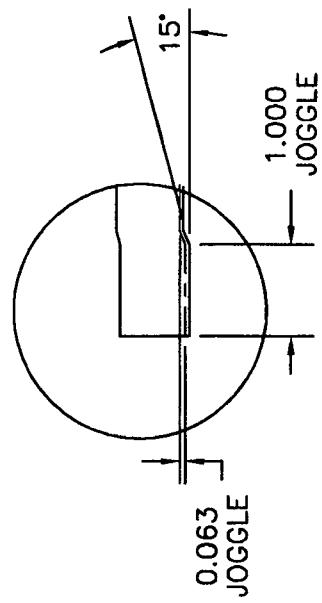
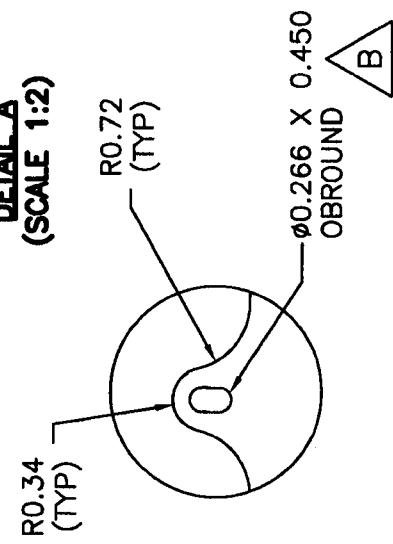
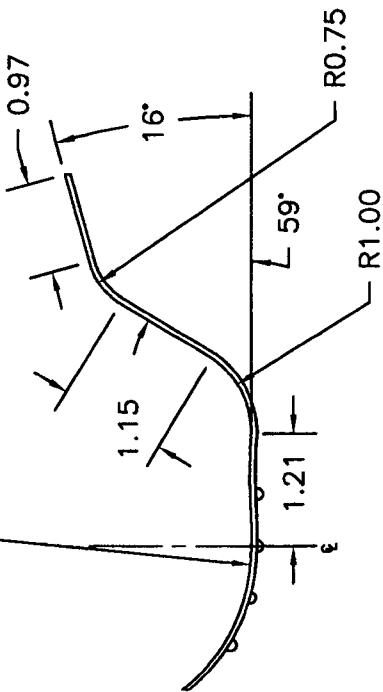
D3315-5 WEARPLATE SHOWN (-6 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,
38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSION ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

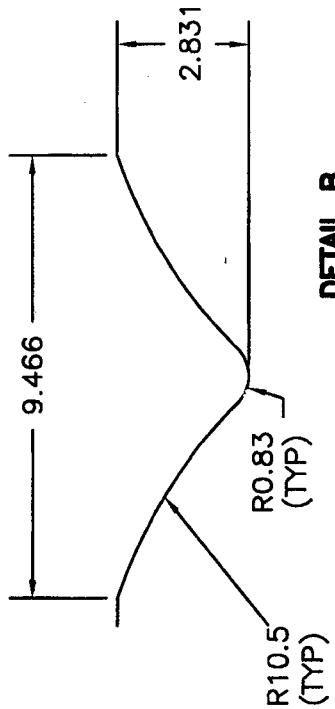
DESIGN P/H	DRAWN BY P/H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3315
DATE 06.01.31		TITLE WEARPLATE
		REV. B SHEET 3 OF 4 SCALE 1:12

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3315	REV. B SHEET 4 OF 4
DATE 06.01.31		TITLE WEARPLATE	SCALE NTS

DETAIL A
(SCALE 1:2)**DETAIL D**
(SCALE 1:2)R2.00^{+0.030}_{-0.000}**SECTION E-E**
(SCALE 1:2)

B

**DETAIL B**
(SCALE 1:4)R2.00^{+0.030}_{-0.000}**SECTION E-E**
(SCALE 1:2)

(-1,-2,-5,-6 ONLY)
7560 HARDCOAT WELD
BEADS (TYP)
0.063 TO 0.125 HIGH

0.56
(TYP)